

Tuesday, 4/4/2006 1:32:41 PM

Kim Johnston

Process Sheet

Split SB 06/05/15

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26515
 Estimate Number : 10913
 P.O. Number : NIA
 This Issue : 4/4/2006 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : LARGE FAB ASSY
 Previous Run : NIA
 Written By : See (comment below)
 Checked & Approved By : 06.04.04
 Comment : Est A 05.09.01 New issue KJ/JLM

Drawing Name : LUG ASSEMBLY
 Part Number : D3405043
 Drawing Number : D3405 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : NIA
 Due Date : 4/27/2006 Qty: 20 Um: 30 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 952
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3405
 Material release note is required
 Identify as D3405-3

06/04/06 (30)

2.0 D34053F GHW Bracket



Comment: Qty.: 1.0000 U(s)/Unit Total: 30.0000 U(s)
 G H W BRACKET

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

06/04/18

30

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3405

06.04.24

30

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr
 Form using DT8204 as per Dwg D3405

MF 06.05.13

SB 06/07/12 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:32:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 26515

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 26515 (20)

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

*B26536
M18712*

PD 06-07-28 (20)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

PD 06-07-28 (20)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06/07/28 (20)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-08-01 (20)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 6/8/03 (20)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 77

PD 06/08/03 (20)

(20)

*Computer says the job has
ALready been Completed (?)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/08/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:32:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 26515

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: 06/08/05 (circled)
le 5608-09

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

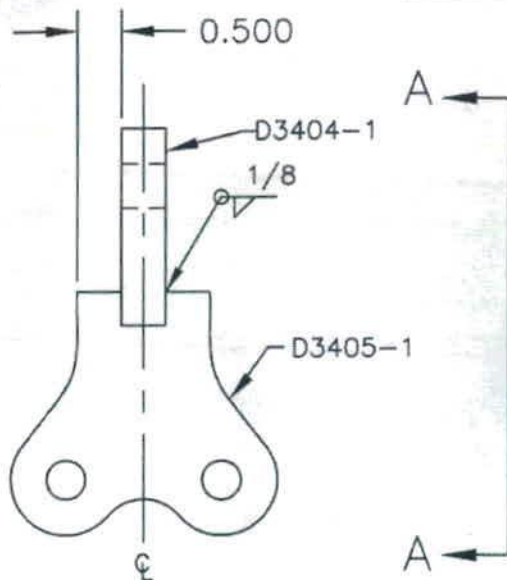
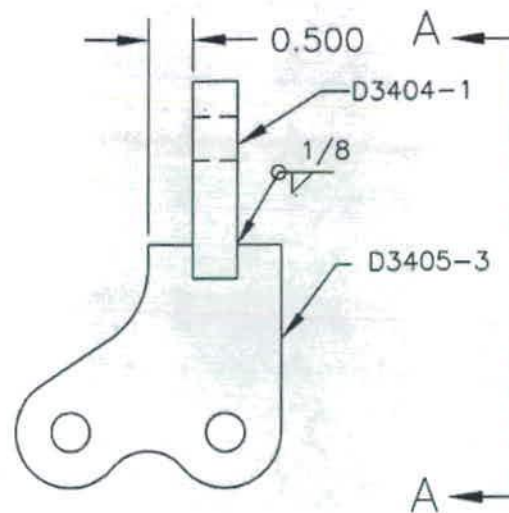
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

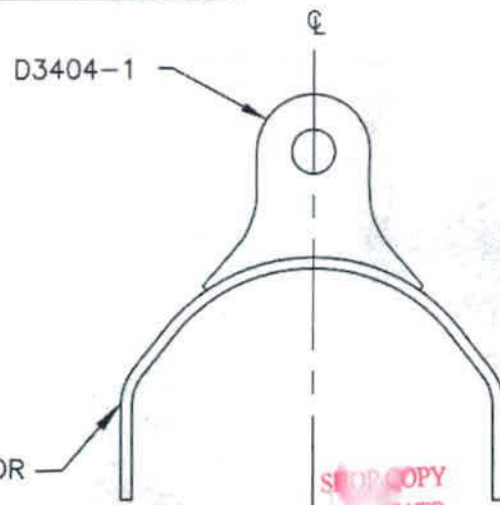
DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09 *[Signature]***D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES



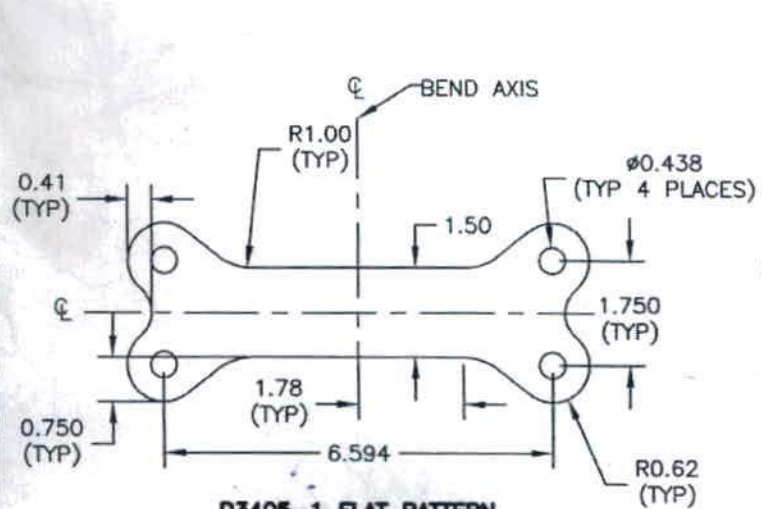
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WITHOUT NOTICE
WORK ORDER
NO. **26515**

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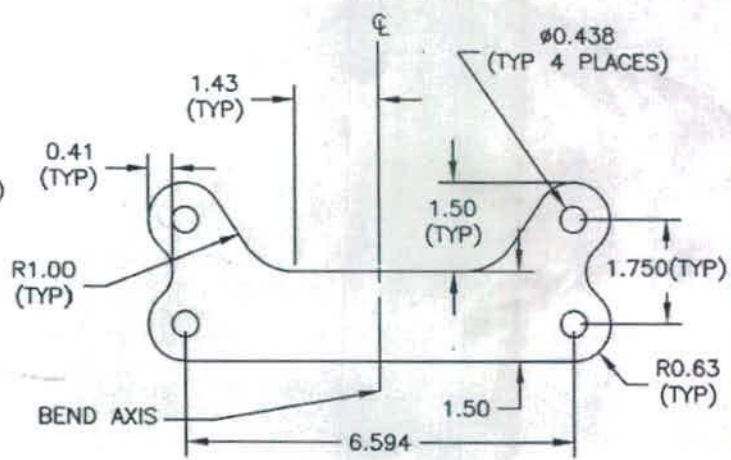
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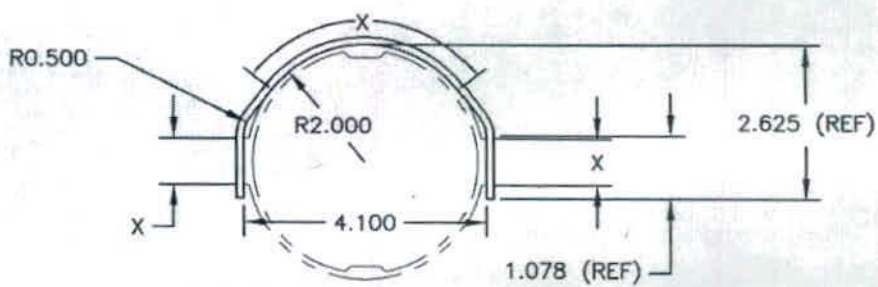
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PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
05.03.08		D3405
DATE	TITLE	SCALE
	GHW LUG ASSEMBLY	1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-08-08
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INDUSTRIAL LASER CUTTING + DART

04/18/2006 10:05 FAX 604 946 4153

90277641

MATERIAL TEST/INSPECTION CERTIFICATE

YIEH MAU CORP.

INVOICE NO. : P05MC11
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

工廠:高雄路竹鄉順發路845號
318, SIKUN AN RD. LU CHU HSIAO
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)872685 FAX:(07)8973095
CERTIFICATE NO: F05MC11
DATE OF ISSUE:01/05/2004
PAGE:4

SPECIFICATION : AISI 304
CUSTOMER : INTEGRIS METALS LTD.

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test QL=50 min					Chemical Composition (%)							
			KGS	LBS			YS	TS	EL	HFH	RV	C	Si	Mn	P	S	Ni	Cu	N
							(N/mm ²)	(N/mm ²)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
AISI 304, 2B FINISH, WITH PAPER INTERLEAVED, SLITTED EDGE																			
7427-4085	120A\60"X 96"	1	1,444	3,183	YU140116	4B320313B-213	299	666	60	83	164	4.7	48	124	32	8	808	1620	2.8
7427-4086	120A\60"X 96"	1	1,445	3,186	YU140116	4B320313C-11	299	666	60	83	164	4.7	48	124	32	8	808	1626	2.8
7427-4127	120A\60"X 120"	1	1,141	2,515	YU140116	4B320313C-12	299	666	60	83	164	4.7	48	124	32	8	808	1626	2.8
7427-4127	120A\60"X 120"	1	1,141	2,515	YU140116	4B320313C-13	299	666	60	83	164	4.7	48	124	32	8	808	1626	2.8
7427-4127	120A\60"X 120"	1	1,141	2,515	YU140116	4B320313C-14	299	666	60	83	164	4.7	48	124	32	8	808	1626	2.8
7427-4127	120A\60"X 120"	1	1,141	2,515	YU140116	4B320313C-15	299	666	60	83	164	4.7	48	124	32	8	808	1626	2.8
7427-6493	110A\48"X 56"	1	1,473	3,247	YU140203	4B320313B-14	299	666	60	83	164	4.7	48	124	32	8	808	1626	2.8
7			8,926	19,676															
NO MERCURY CONTAMINATION																			
Dead (not good for all) Heat NO.																			

NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN WAS
MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

Dead (test good for all) Heat NO.

● PRIME MATERIAL, NO DING, NO DENTS, NO SCRATCHES
● P.O. NO. 804464 (VANCOUVER)
● SALES CONTRACT NUMBER: P05MC11
● DOCUMENTARY CREDIT NUMBER: J11857060249

YIEH MAU CORP.
Lisa Kuen Hsing
Manager of Quality Assurance Section

